





DUPLICATE



Work Order ID 48667B

July 8, 2009 8:35:10 AM

Page 1


Item ID: D2512 Accept  Setup Start   
Revision ID: E Stop   
Item Name: Basket Lid 205/350  
Start Date: 07/15/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 08/03/2009 Req'd Qty: 1.00  Customer:


Reference:

Approvals: Process Plan: MF Date: 09-07-08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	Rev E

100  Large Fab 0.00  
Large Fab Memo 0.00  
Large Fab 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512-1 2-Cut (4) D2236 From  
D3166-3 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

110  QC9- Inspect visual per QSI004- Fusion Welds 0.00  
QC Memo 0.00  
Quality Control

CL 09-07-08  
SAD 09-07-07  
SY 09/07/08

PD 09-07-08

# Work Order ID 48667B



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Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 802107/08 (X)

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat 2- ST  
COAT: START TIME: 2:00pm FINISH TIME: 4:00pm OVEN TEMPERATURE: 400°C  
COAT: START TIME: 2:30pm OVEN TEM

pressure wash 08-07-08 (X)  
1112148/111472

140

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4  
Batch: m11013 wing walk

Batch: m110907 Black spray paint

UMD 08/07/09 (X1)

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Item ID: D2512

Accept

Revision ID: E

Item Name: Basket Lid 205/350

Start Date: 07/15/2009 Start Qty: 1.00

Required Date: 08/03/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



⇒ 50962109

9/7/10

09603113

MF 09-07-10

# Picklist Print

Page 1

July 8, 2009 8:35:10 AM

Work Order ID: 48667B

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	12.0000	2.0000			
												
Basket Hinge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

48230

12

D2327-1RevD

Manufactured

No

100

Each

20.0000

2.0000



Spacer Bushing

2x

SY 09/07/08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

46325

20

D2581RevA1

Manufactured

No

100

Each

35.0000

2.0000



Mounting Bracket

2x

SY 09/07/08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

46086

2

48428

33

D3166-3RevA1

Manufactured

No

100

Each

0.0000

1.0000



Basket Hoop

2x

SY 09/07/08

B48429

1x

SY 09/07/08

# Picklist Print

July 8, 2009 8:35:10 AM

Work Order ID: 48667B

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	868.5700	18.0000			



Expanded Metal Flat SS

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

868.57

108152

90

110134

6.7

110292

14.4

110629

14.41

110861

21.18

110992

0.58

111444

17.79

111630

35.15

111956

46.36

112147

622

M304TS0.750W.065

Purchased

No

100

f

463.0861

45.8741



304 SQ Tube .75x.75x.065W

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

463.0861

110969

3.29

111148

15.96

111331

1.96

111432

0.44

111885

25.14

112051

416.2961

→ 18.00 SAP 09-07-06

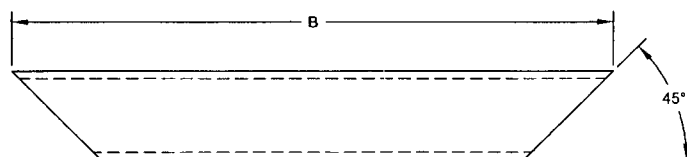
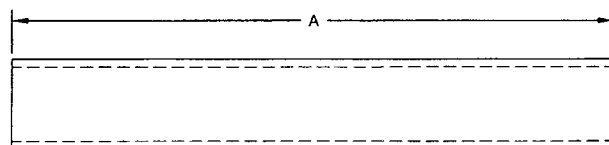
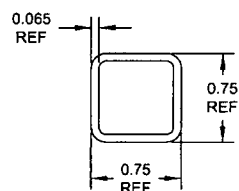
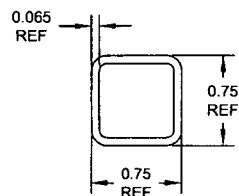
→ 45.8741 SAP 09-07-06

July 8, 2009 8:35:10 AM

Shop Packet Print

# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



48667B

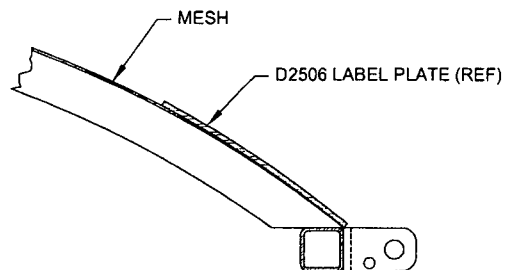
**RELEASED**  
08-08-21/10



## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



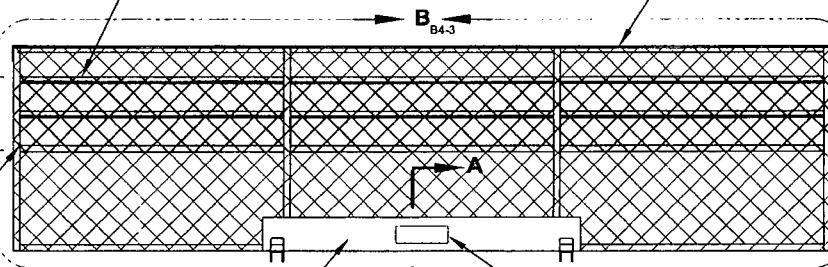
**SECTION A-A B3-2**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

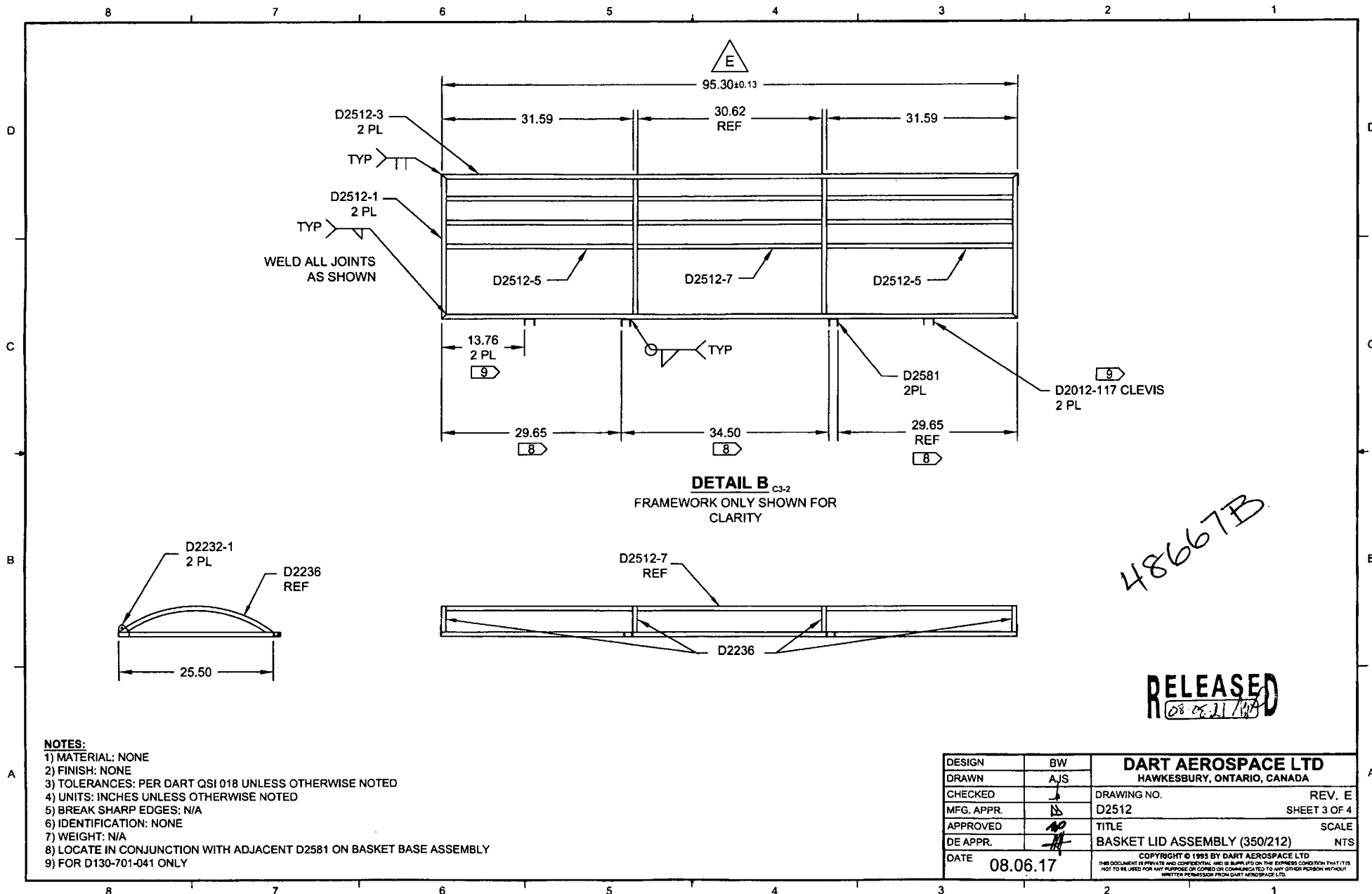
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



48667B

**RELEASED**  
08.06.17

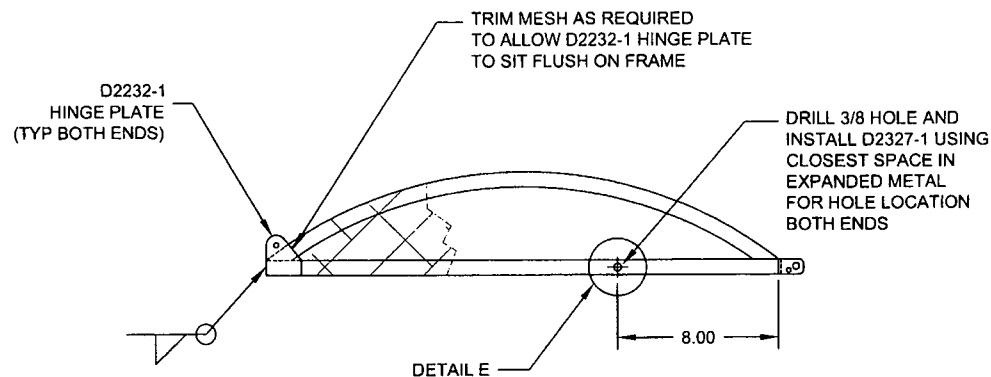
DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
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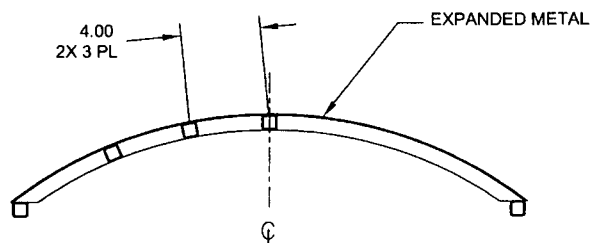
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DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	JB	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	JH	BASKET LID ASSEMBLY (350/212)	NTS
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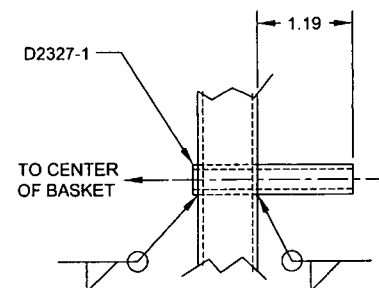
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

48667B

**RELEASED**

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1